

Work Order ID 138046***138046***

Page 1

Thursday, October 22, 2015 7:32:28 AM

Item ID: D3693-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rod End Bearing

Start Date: 10/21/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/21/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: ML5Date: OCT 22 2015

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3693	C								

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 30031

Purchase Part Number: 047-140-252-005

Supplier: Bell

Certificate of conformity is required

CZ OCT 23 2015 2

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

2X SP 15-10-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

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Quality Control

2

DAS
38
9-89
OCT 30 2015

2 FF

NOV 03 2015

②

DAS
38
9-85

NOV 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Thursday, October 22, 2015 7:32:28 AM

Item ID:	D3693-1	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Rod End Bearing				Stop	*NS2*
Start Date:	10/21/2015	Start Qty:	2.00	*2*	Cust Item ID:	
Required Date:	10/21/2015	Req'd Qty:	2.00	*2*	Customer:	
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Thursday, October 22, 2015 7:32:32 AM

Page 1

Work Order ID: 138046

138046

Parent Item: D3693-1

D3693-1

Parent Item Name: Rod End Bearing

Start Date: 10/21/2015

Required Date: 10/21/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-01-17 JLM Verified By:EC
IPP Rev:B As per Rev B 09-01-20 JLM Verified By:DD IPP
REV:C 13.01.24 PER ECN12-693 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

047-140-252-005

Purchased

No

Each

0.0000

2

047-140-252-005

Rod Bearing End

**

2x 8015-10-30

DQA: _____ Date: _____

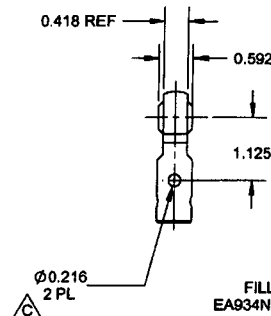
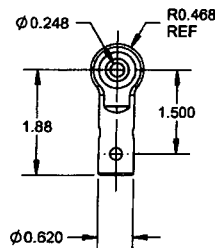


WORK ORDER NON-CONFORMANCE / UPDATE

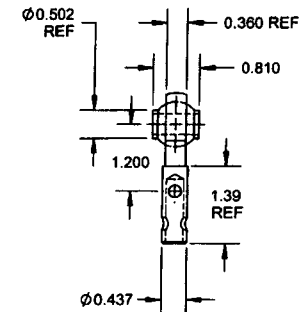
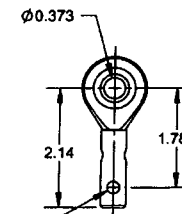
QA Closed: _____ Date: _____ Work Order update only ☐

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Root Cause		FAULT CATEGORY							
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

SPECIFICATION CONTROL DRAWING



△ 0.216
2 PL
PRIOR TO DRILL
FILL ROD END WITH HYSOL
EA934NA OR MAGNOBOND 6398
ADHESIVE,
CURE AS PER MANUFACTURER'S
INSTRUCTION



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

**D3693-1
ROD END BEARING**

**D3693-3
ROD END BEARING**

RELEASED
2013-01-22
WD

DART P/N	DESCRIPTION	BELL P/N	WEIGHT (lb)	FINISH	IDENTIFY
D3693-1	ROD END BEARING	047-140-252-005	0.19	NONE	NONE
D3693-3	ROD END BEARING	205-060-101-001	0.14	NONE	NONE

REV.	DESCRIPTION	BY	DATE
C	0.216 PILOT HOLES WERE 0.189, (ZN B6-1, C4-1) REF NCR12-2074	DB	12.12.05
B	REMOVED SHADED VIEW (ZN D8-1, D1-1); 0.592 WAS 0.591 (ZN C5-1); REFORMATTED SHEET; TRANSFORMED GENERAL NOTES TO TABLE FORMAT	RF	08.12.15
A	NEW ISSUE	RF	08.03.12
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3693	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ROD END BEARING	NTS
DATE	12.12.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO30031

Purchase Order Date 10/6/2015 10:42:20 AM

PO Print Date 10/23/2015

Page Number 1 of 2

Order From : VU-EAG002

EAGLE COPTERS MAINTENANCE LTD.
823 MCTAVISH ROAD N E
CALGARY, AB T2E 7G9
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone 403-250-7370

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect



Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	047-140-252-005 AS PER DWG D3284 REV. B B137519	Rod Bearing End	10/27/2015 Yes 10/27/2015		4.00 Each	\$108.56	\$434.24
Line Total:							\$434.24
3	047-140-252-005 AS PER DWG D3693 REV. C B138046	Rod Bearing End	10/27/2015 Yes 10/27/2015		2.00 Each	\$108.56	\$217.12
Line Total:							\$217.12

Note:

10/23/2015

Eagle Copters Maintenance Ltd

823 McTavish Rd, NE
Calgary, Alberta T2E 7G9
Canada

Telephone: (403) 250-7370

October 28, 2015

Fax: (403) 250-7110

Shipment number: SH#15-003144

Ship To: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Via: FEDEX

Phone: (613)632-5200

Waybill: 774849802020

Item	Part / Tool Number	Part / Tool Description	Current Location	Qty	UOM	Serial Number	Lot Number/Tool ID
1	047-140-252-005	BEARING	Shipping Area	2	Each		LT-15-009875

Type of sale: Outright

Customer PO number: 30031

Sales Order Number: SO15-01589.001

*** End of Document ***

SP15-10-30

1. Approving Civil Aviation Authority/Country FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 8056403460-5	
4. Organization Name and Address:  Bell Helicopter A Textron Company		Bell Helicopter Textron Inc. Logistics Center 3200 High River Road Suite 100 FORT WORTH TX 76155		FAA Production Certificate PC-100SW		5. Work Order/Contract/Invoice Number: 4500684061
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status/Work:	
1	BEARING	047-140-252-005	32	N/A	NEW	
12. Remarks: Export airworthiness approval - this article meets the special requirements of Canada						
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12. Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.			
13b. Authorized Signature: 		13c. Approval/Authorization No: ODA-710621-SW		14b. Authorized Signature:		14c. Approval/Certificate No:
13d. Name (Typed or Printed): Thai Tran		13e. Date (dd/mm/yyyy): 31/JUL/2014		14d. Name (Typed or Printed):		14e. Date (dd/mm/yyyy):
User/Installer Responsibilities						
It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block 1. Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.						

Eagle Copters Maintenance Ltd.

823 McTavish Road, NE Calgary, Alberta T2E 7G9

TCCAAMO Approval No. 6-81

LOT #: LT-15-009875



Sold To: SO15-01589

Sold Date: 10/28/2015 12:54:57PM

PART #: 047-140-252-005

Description: BEARING

Serial No:

Condition: New

Qty Sold: 2.00

Cure Date:

Manufacturer: Bell Helicopter (Manufacturer)

	Cycles	Hours
Total Time:		0.
TSO:		
Time Remaining:		

Details of work performed/reason for removal

Receiving Inspection

Additional work to be performed upon installation

October 28, 2015

Inspector

[Signature]

